

Work Order ID 73916

Monday, September 19, 2011 10:17:28 AM



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Item ID: D2362-041

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Pre-Flite Step

Start Date: 9/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 9/23/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2362

Rev E1

100

Weld per dwg A/R Aluminum rod Batch: *118735* 0.00
Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2244 extrusion 3.75" long
Deburr D2244-3.75
Weld D2244-3.75 to D2362-7 as per Dwg D2362and QSI 004

BE 11.10.14

4 *Ø*

105

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

8/10/14

(Signature)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

4 *Ø* *BE 11/10/14*

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Item ID:	D2362-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	350 Pre-Flite Step					
Start Date:	9/19/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	9/23/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<div> <div>M117745</div> <div> <div>Memo</div> <div>START TIME: 1:10</div> <div>OVEN TEMPERATURE: 320 OF</div> <div>FINISH TIME: 1:40</div> </div> </div>									
130 QC Quality Control	QC3- Inspect Part Finish	0.00							
<div> <div></div> <div> <div>Memo</div> <div></div> </div> </div>									
140 HandFinish Hand Finishing	HandFinishing	0.00							
<div> <div></div> <div> <div>Memo</div> <div>M118988</div> <div>Mask bracket and apply black anti-skid paint as per QSI 005 4.4</div> </div> </div>									

4X of M 11/10/19

4 d JH u/10/19
counted

4 d JH u/10/20
counted

Monday, September 19, 2011 10:17:28 AM



Accept

**Setup Start**

Stop



Start Date: 9/19/2011 **Start Qty:** 4.00

**Cust Item ID:**

Required Date: 9/23/2011 **Req'd Qty:** 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop






QC:


Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect part completeness to step on W/O QC3.	0.00				4	BR	11-10-20	
QC Quality Control	7/11/20 Memo	0.00							
160 	Identify as per dwg & Stock Location: 485	0.00							
Packaging Packaging	Memo	0.00							11/10/20 (2)
170 	QC21- Final Inspection - Work Order Release	0.00							11/10/20
QC Quality Control	Memo	0.00							ME

11/10/2018 (2/3)

11/10/24 
MF
(1-10-20

Picklist Print

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Page 1

Work Order ID: 73916

Parent Item: D2362-041

Parent Item Name: 350 Pre-Flite Step

Start Date: 9/19/2011


Required Date: 9/23/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C 00.06.26 Removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2244-116  Step Extrusion		Manufactured	No			100	Each	101.5000	1	4		11.10.04	
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Location	Loc Qty	Loc Code
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HALL	91	
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60307	91	
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WA	10.5	
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60307	10.5	
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D2362-7  Support Bracket		Manufactured	No			100	Each	0.0000	1	4		11.10.13	
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B70060 = 4

DART



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 3
KE		D2362	
DATE	TITLE	SCALE	
98.12.04	STEP SUPPORT BRACKET	1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

01.03.15 CP

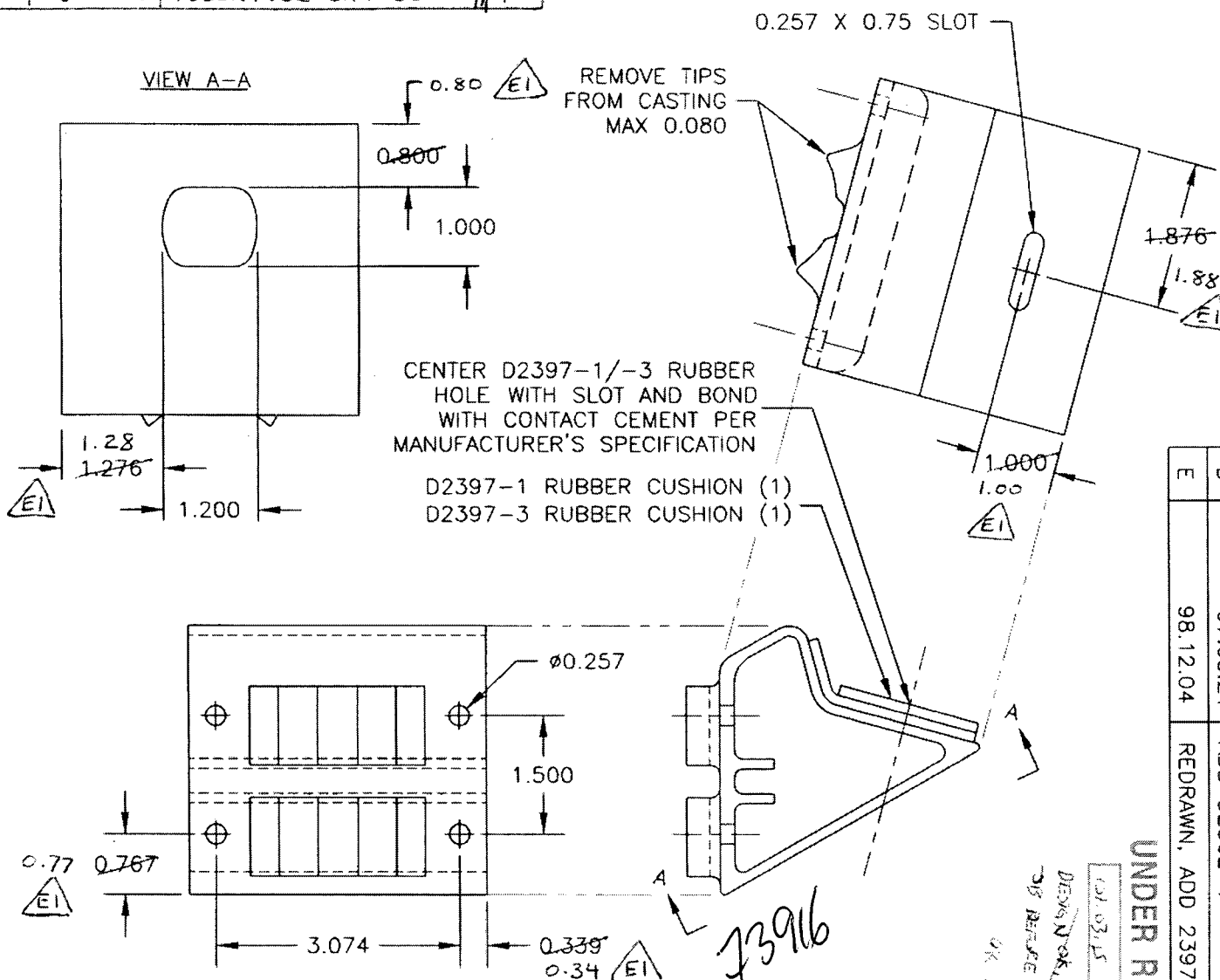
DESIGN OK, BUT CHECK WITH
OR REUSE MANUFACTURE

OK 4/11/04

73916

D2362-3

EI 03.10.07 TOLERANCE CHANGE ~~RT~~

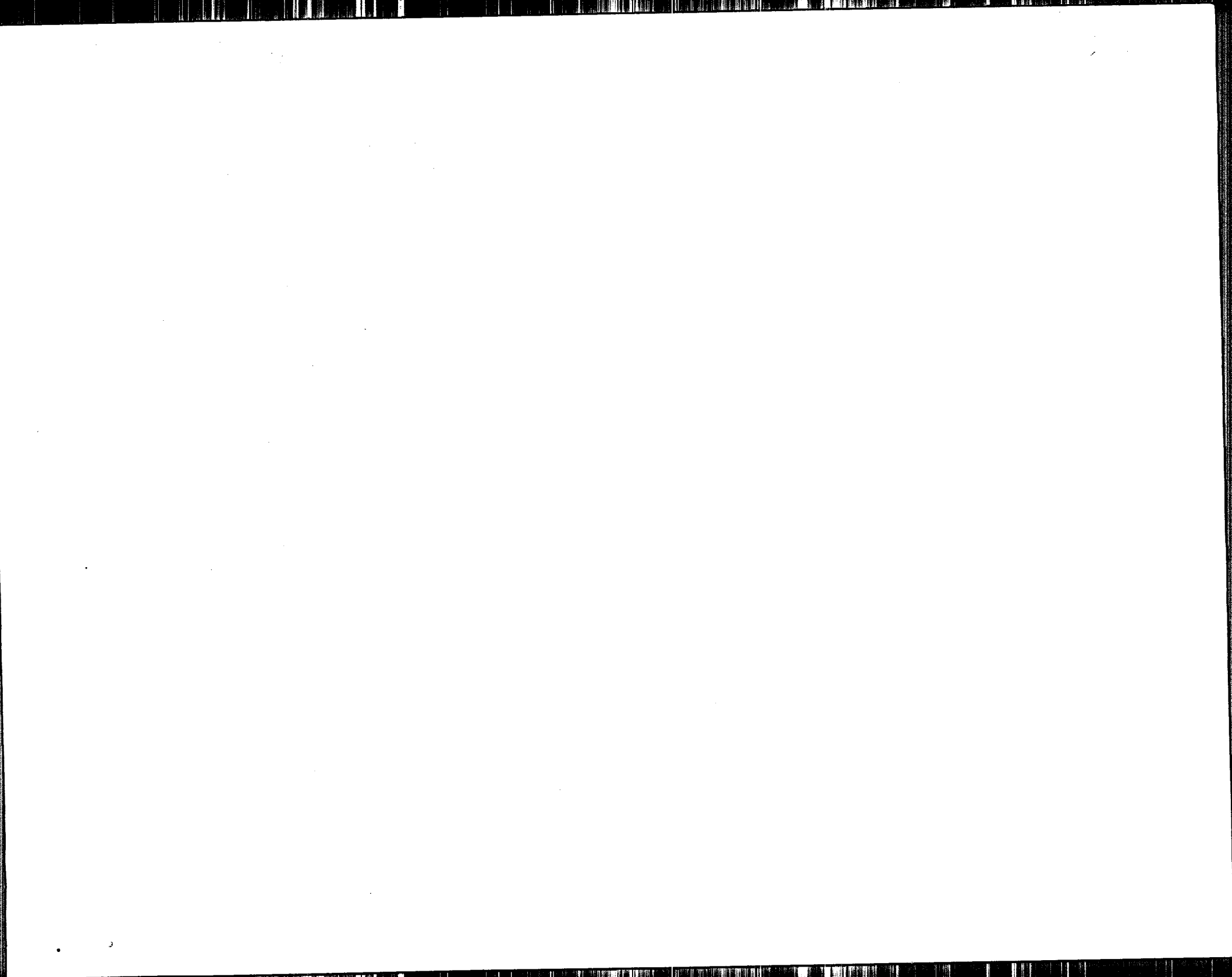


NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

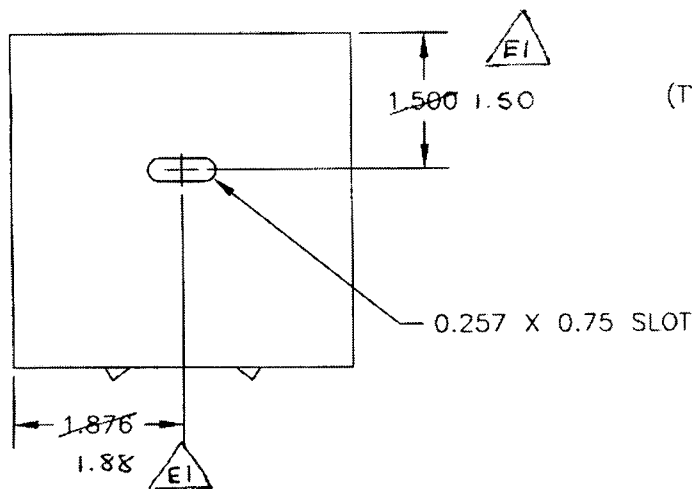
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





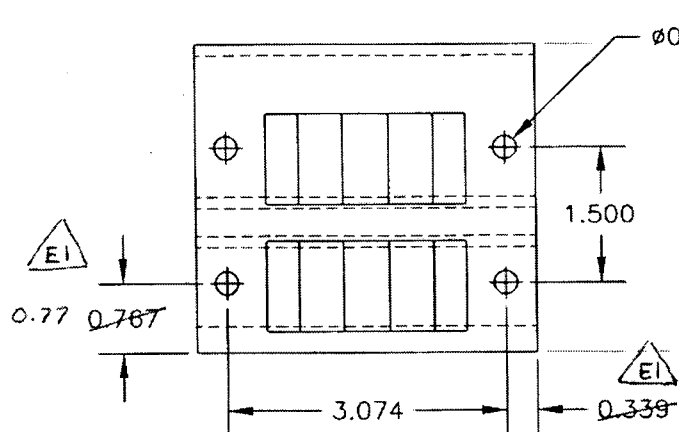
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3
KE	MP	D2362	
DATE	TITLE	SCALE	
98.12.04	STEP SUPPORT BRACKET	1:2	

VIEW A-A



MACHINE TO
R1.100
(TYP 2 PLACES)

REMOVE TIPS
FROM CASTING
MAX 0.080



BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

D2362-1 & D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
1998.12.14
UNDER REVIEW

DESIGNER: BRYAN LEE
DRAFTSMAN: PAUL TOLSON
DATE: 98.12.14

73916

D2362-041 (SHOWN)

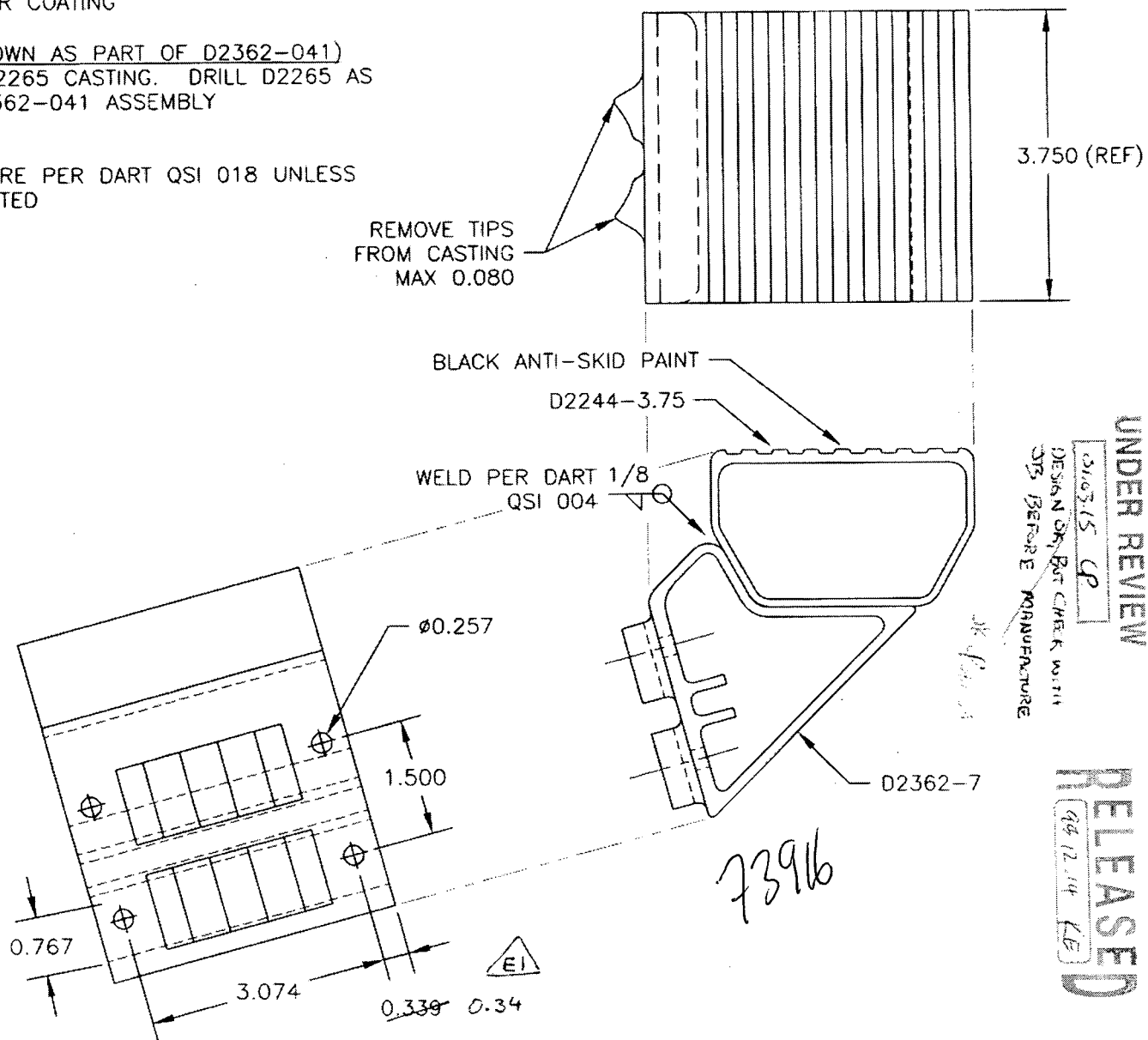
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DART



DESIGN	DRAWN BY	DART AEROSPACE LTD
BW		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. E
KE	KE	D2362
DATE	TITLE	SHEET 3 OF 3
98.12.04	STEP SUPPORT BRACKET	SCALE
		1:2

UNDER REVIEW

010315 CP
DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED
98.12.14 KE